Work Order ID 75581

75581

October 26, 2011 7:20:45 AM

Item ID: D2232-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Basket Hinge

Start Date: 10/26/11 **Start Qty:** 20.00 *20*
Required Date: 10/27/11 **Req'd Qty:** 20.00 *20*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** CL **Date:** 11/10/26 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2232	Rev C								
100		0.00							
100	FLOW WATER JET					BH-10-26			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2232 Dwg Rev: C Prog Rev: C 2-								
304.125	Deburr if necessary					(20)			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						BH-10-26			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120						(21)			
QC	**Memo**	0.00							
Quality Control									

S 11/10/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D2232-3 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Basket Hinge
Start Date: 10/26/11 **Start Qty:** 20.00 *20*
Required Date: 10/27/11 **Req'd Qty:** 20.00 *20*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00	PL 11.10.27			21	Ø		
130									
Small Fab	**Memo**	0.00							
Small Fab	Deburr								
140	Identify as per dwg & Stock Location: WA	0.00	PL 11.10.27			21x	Ø		
140									
Packaging	**Memo**	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
150	QC21- Final Inspection - Work Order Release	0.00							
150								11/10/27	
QC	**Memo**	0.00							
Quality Control									

PL 11-10-27 21

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

October 26, 2011 7:20:45 AM

Work Order ID: 75581

Parent Item: D2232-3

Parent Item Name: Basket Hinge

Start Date: 10/26/11 **Required Date:** 10/27/11

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP B01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	113.5100	**0.0694**	**1.4610526**			

Location	Loc Qty	Loc Code
MAT020	113.51	
117494	1.21	
119006	50.5	
119048	61.8	

B11-10-26

117494

2

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

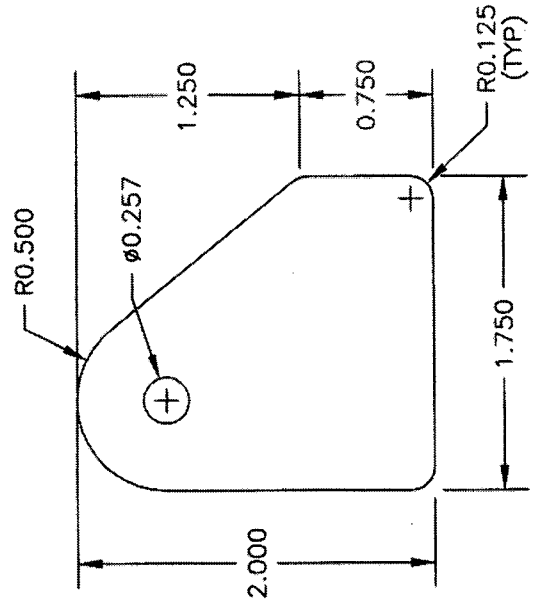
DART

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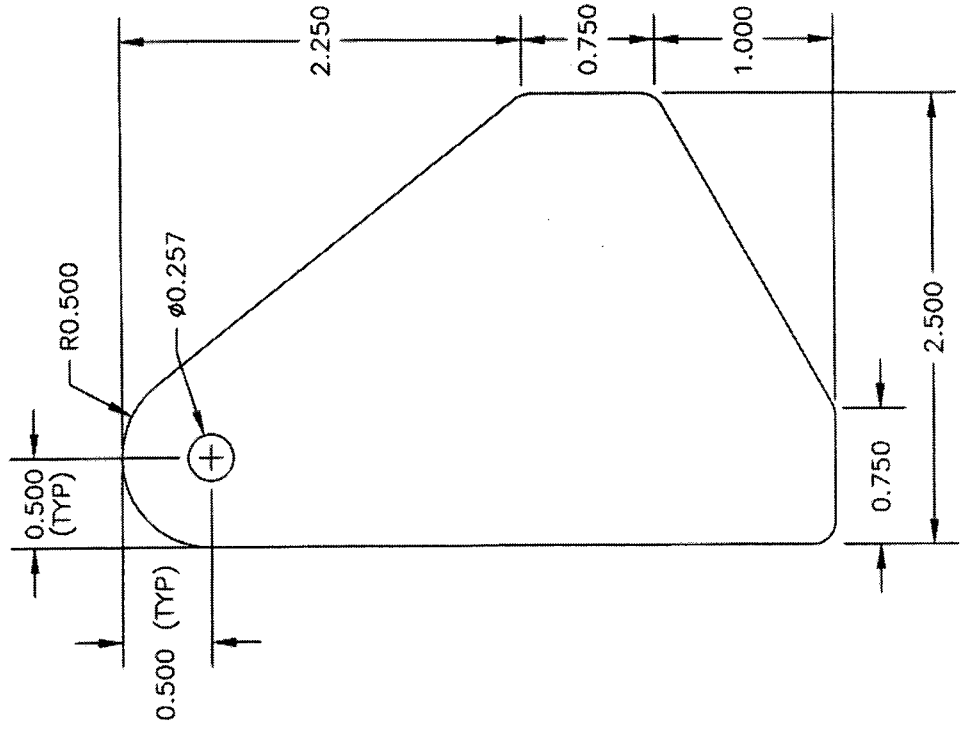
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1

A	94.05.12	NEW ISSUE
B	96.01.02	ADDED -5 AND -7
C	98.04.28	0.125 THICK WAS 0.063

RELEASED
98.05.05 KE



D2232-1



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

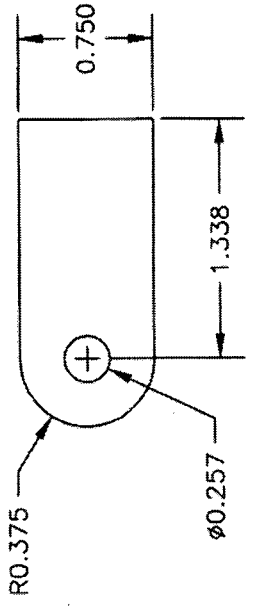
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

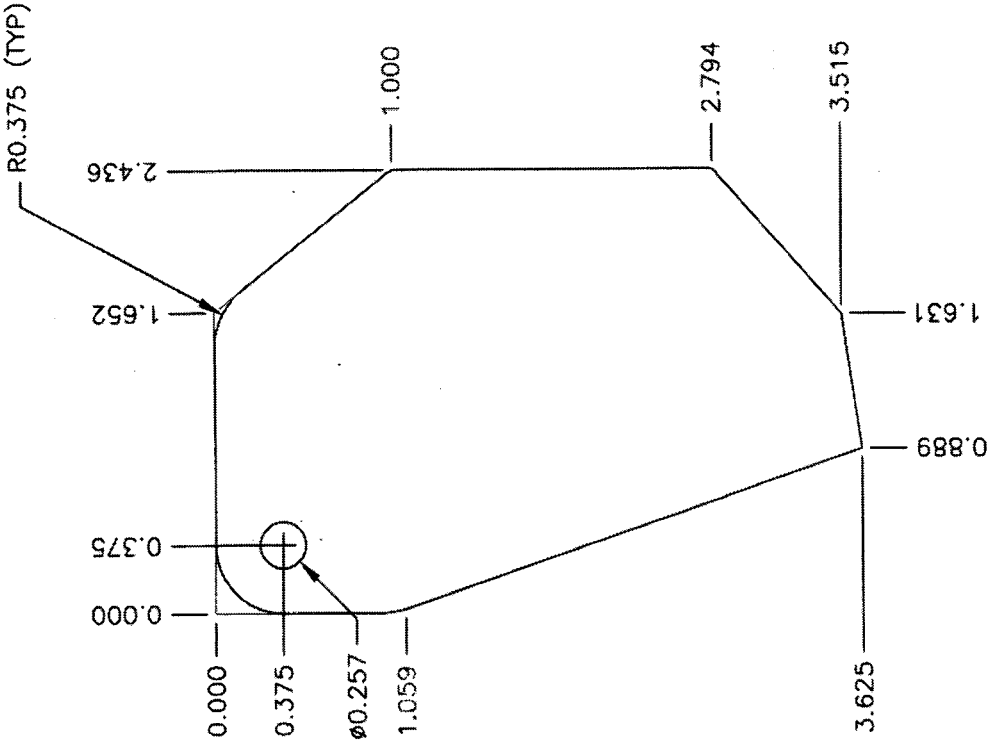
DESIGN	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2232 — REV. C SHEET 2 OF 2
DATE 98.04.28		TITLE BASKET HINGE — SCALE 1:1

COPY (ISSUED)

RELEASED
98.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

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DART AEROSPACE LTD	Work Order:	75581
Description: Basket Hinge	Part Number:	D2232-3
Inspection Dwg: D2232 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.500	1		V B02	
0.750	+/-0.010	.750	4		V	
2.500	+/-0.010	2.509	5		V	
1.000	+/-0.010	1.000	2		V	
0.750	+/-0.010	7.50	3		V	
2.250	+/-0.010	2.250	3		V	
0.500	+/-0.010	.500	1		V	
Ø0.257	+0.006/-0.001	.258	1		V	

Measured by:	
Date:	11-10-26

Audited by:	
Date:	11/10/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	